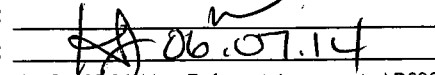
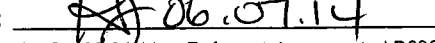


Date: Friday, 7/14/2006 12:01:39 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING  
 Job Number : 27924B  
 Estimate Number : 10395  
 P.O. Number : N/A Part Number : D29685  
 This Issue : 7/14/2006 S.O. No. : N/A Drawing Number : D2968  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B1  
 Previous Run : 26210B Material : NA  
 Due Date : 8/20/2006 Qty: 40 Um: Each  
 Written By :   
 Checked & Approved By :   
 Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NT3000W500 4130 Tube 3"ODx.5"W



Comment: Qty.: 0.0218 f(s)/Unit Total : 0.8736 f(s)

Material: AISI 4130 ~~Ø 3/4" Bar~~

(M4130N-R0.750)

Batch: 

Identify AS D2968-1

18948

BC 06.07.18 40


2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE

1-Turn Blank as per Folio FA049 and Dwg D2968

2-Deburr, no sharp edges

 06/09/07 40

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 06.07.18 40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.G 06/09/09 40

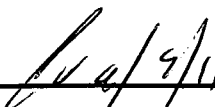
5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 396



(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/09/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Friday, 7/14/2006 12:01:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 27924B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

SD 06/09/11

Job Completion



u 06-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	27924B
<b>Description:</b> Tow Ring		<b>Part Number:</b>	D2968-5
<b>Inspection Dwg:</b> D2968 <b>Rev:</b> B1			<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

**X**

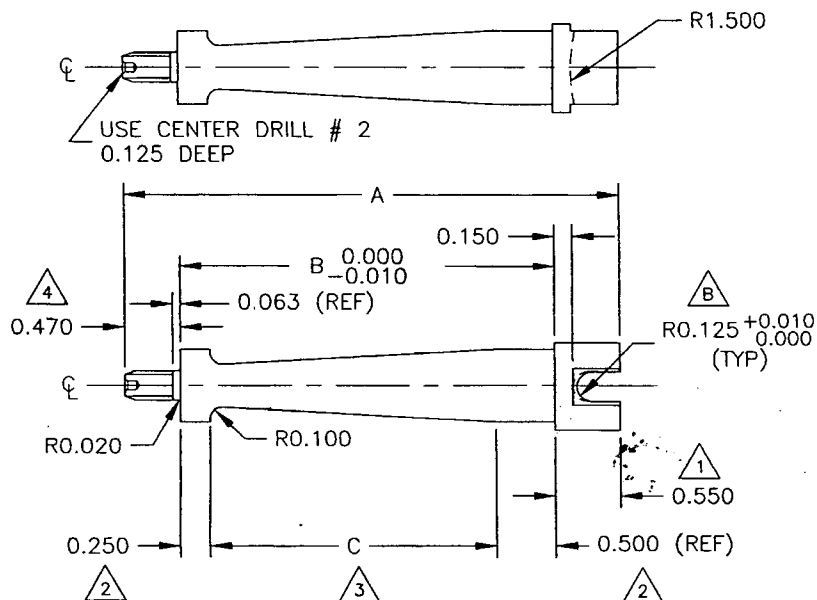
## First Article

## Prototype

[illegible]

Measured by: <i>BC</i>	Audited by: <i>EN</i>	Prototype Approval: N/A
Date: <i>06-07-18</i>	Date: <i>06/07/18</i>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D2968-041/-043	KJ/RF	[Signature]



D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ 0.750 O.D.

△ 0.625 O.D.

△ MACHINE UNIFORM TAPER FROM 0.363 O.D. TO 0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP

MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

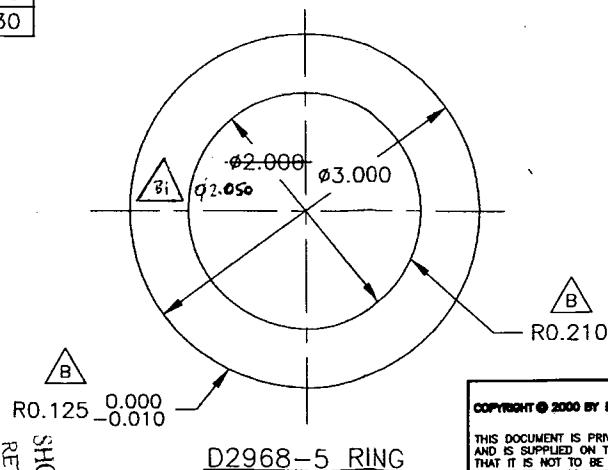
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

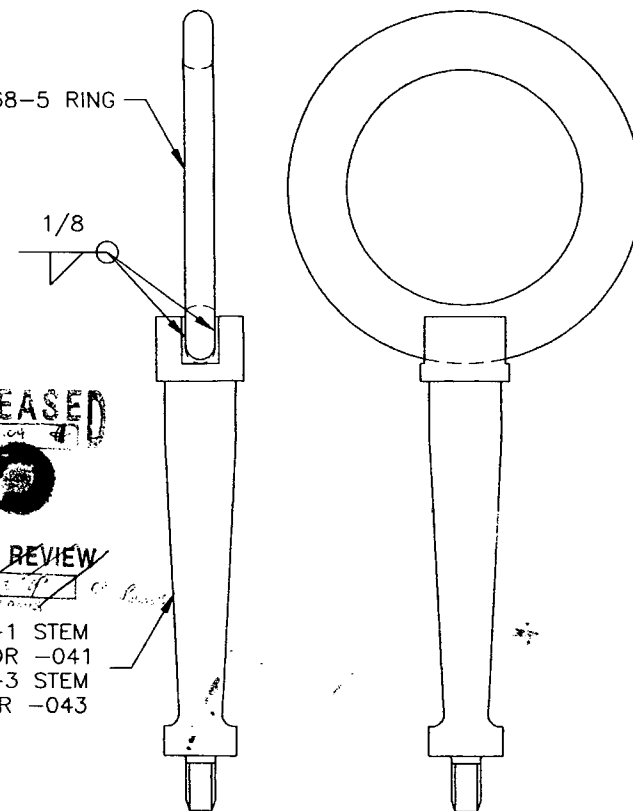
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27924B



RELEASED

UNDER REVIEW

USE 2968-1 STEM  
FOR -041  
USE 2968-3 STEM  
FOR -043



D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING

HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER:

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°	
A	00.03.07	NEW ISSUE	
DESIGN	#	DRAWN BY	#
CHECKED	#	APPROVED	#
DATE	00.05.31	TITLE	TOW RING
DRAWING NO.		REV. B	
D2968		SHEET 1 OF 1	
SCALE		1:1	

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